



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

D3580-1

Job Sheet 181167



Part No: D3580-1

Job Qty: 30 ea

Part Name: Joggle Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev :A New Issue 07.06.25 EC IPP Rev:B Removed Powder Coat 07-07-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Waterjet		SC 8/07/18
100	Waterjet	30 pcs	8/17/18	8/17/18	0.00	0.58	Waterjet1		SC 8/07/18
120	QC	30 pcs	8/17/18	8/17/18	0.00	0.00	QC8		38
130	Small Fab	30 pcs	8/17/18	8/17/18	0.01	0.97	Small Fab-4		9-89 DAS
140	QC	30 pcs	8/17/18	8/17/18	0.00	0.00	QC5		AS 38
150	Packaging	30 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3	50406	AUG 23 2018 38
60	QC21-SA	30 Ea	8/17/18	8/17/18	0.00	0.00	QC21	1-89	AUG 23 2018 38
									21 9-89 AUG 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.2700 sf (.009 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	0	289	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Joggle Bracket	0.194inches + 0.005 - 0.001	0.199 0.193	0.196	
2	Joggle Bracket	1.750inches ± 0.030	1.780 1.720	1.749	
3	Joggle Bracket	0.750inches ± 0.030	0.780 0.720	0.751	
4	Joggle Bracket	0.294inches ± 0.010	0.304 0.284	0.293	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																			
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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval																																				
Description Work Order Deviation				Disposition																																							
Completed By _____ / Supervisor Verification Coordinator Approval Signed Wrong Dimensions Under tolerance incorrect post/Missing moved ng Finish Misread Turning Sequence Root Cause <table style="width:100%; border: none;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td><td>Pressure/Fc ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td><td>Bending ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td><td>Centre Not ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td><td>Cracks ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td><td>Crimp/Kink ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td><td>Cuffs ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td><td>Crushing ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td><td>Heat Treat ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td><td>Wave/Twist in Tube ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td><td>Marks/Chatter ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td><td></td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td><td>OTHER : _____</td></tr> </table> Date: 07/26/18 Instructions: Various STC's Part: D3580-1 Job No: 181167 Serial No/Batch: S096780 Revision: _____ Inspector: _____ Exp Date: _____								Environment ☐	No Re-verification ☐	Pressure/Fc ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER : _____
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